

Work Order ID 69225

Thursday, May 05, 2011 11:46:56 AM



Page 1

Item ID: D3391-025

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Tube Assembly

Start Date: 5/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 11-05-5

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	Rev H/ DEO								



Mori Seiki

Mori Seiki CNC Lathe Large

MORI SEIKI CNC LATHE LARGE

Memo

Turn as per Folio FA599

Rev: AA & Dwg D3391 Rev: H

scribe batch # on fwd end at 90 degree

0.00

0.00

J.F.S. *[Signature]* 11/05/11 *[Signature]* *[Signature]*



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

J.F.S. *[Signature]* 11/05/11 *[Signature]* *[Signature]*



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

[Signature] 11-05-31 *[Signature]* *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 Memo 1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: 4 2-Deburr	0.00 0.00	B.A	11/05/24		1	0		
130 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	B.A	11/05/24		1	0		
140 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		11.05.24		1	0		

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Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803		DP	11-5-31					
160 	BENDING MACHINE - SKIDTUBES	0.00							
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Form as per Dwg D3391 Using Bend Prog 3391025		DP	11-5-31					
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control			H- 4.150"	1 - 0					BE 11/05/31

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Start Date: 5/5/2011 Start Qty: 1.00

Required Date: 5/20/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217
Wearplate Jig.

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe, wearplate to 0.297"and float bag holes to 0.328" as per
Dwg D3391.

7-Deburr

11-6-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

200

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

IX ~~Ø~~ M. 4/06/02

DP 11-6-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 5/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: <u>4116677</u> exp. date: <u>2001/08/30</u> cure time 12hrs as per QSI0015								
230		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
235		0.00							
	Pressure Wash per QSI005 4.3								
HandFinish	Memo	0.00							
Hand Finishing	AND REALODINE AS PER PAR09-043								

JP 11-6-3

Sulob66

IX Ø M-1 11/06/06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

1X ~~0~~ M-f 11/06/07

250

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

1 ~~0~~ M 11/06/07

260

HandFinishing

0.00



HandFinish

Hand Finishing

Memo

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/ R. Sikaflex-241/-291 11/16/05

Sikaflex expiry date: 12/06

0.00

1 ~~0~~ M 11/06/07

W/O:		WORK ORDER CHANGES					
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Item ID: D3391-025

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
280 Packaging Packaging	Identify as per dwg & Stock Location: <u>w/o</u> Memo	0.00 0.00				1	0	11/06/07	
290 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/6/8

11/11-06-8

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, May 05, 2011 11:47:03 AM

Page 1

Work Order ID: 69225

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly



Start Date: 5/5/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM ☐ ☐ ☐
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6014-090 ALUMINUM EXTRUSION		Manufactured	No			100	Each	11.0000	1	1			

Location Loc Qty Loc Code
 LG 11

D3670-4-200 SPACER		Manufactured	No			230	Each	58.0000	4	4			
---------------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

56572

Location Loc Qty Loc Code
 LG B68950 58
 68107 58

D2646 Aft Cap		Manufactured	No			270	Each	47.0000	1	1			
----------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location Loc Qty Loc Code
 FP006 43
 62678 43
 FP-4 4
 69019 4

mmc 11/05/11

4 DP 11-6-3

ml 11/06/02

xl

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Picklist Print

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Page 2

Work Order ID: 69225

Parent Item: D3391-025


Parent Item Name: Aft Tube Assembly

Start Date: 5/5/2011

Required Date: 5/20/2011


Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No 270 Each 20.0000 1 1

 Wearpad


Location	Loc Qty	Loc Code
FP017	20	368944
63313	2	
66135	14	
66935	4	

Handwritten: 11/06/07

D3537-7 Manufactured No 270 Each 10.0000 1 1

 Wearpad


Location	Loc Qty	Loc Code
FP017	10	
56831	3	
65146	7	

Handwritten: 11/06/07

D3553-1 Manufactured No 270 Each 22.0000 1 1

 Gasket

Location	Loc Qty	Loc Code
FP013	22	
56568	22	

Handwritten: 11/06/07

D3553-3 Manufactured No 270 Each 46.0000 1 1

 Gasket

Location	Loc Qty	Loc Code
FP	20	
31631	20	
FP013	26	
53480	26	

Handwritten: 11/06/07

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

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Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 5/5/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No

270 Each

1,379.000 2 2



Phenolic Washer



all 11/06/07

Location

Loc Qty

Loc Code

FP-A

29

52505

29

ST074

1350

64177

850

66821

500

x2

ALS4-1032-130 Purchased No

260 Each

1,338.000 14 14



Insert



all 11/06/07

Location

Loc Qty

Loc Code

ST281

1338

117331

1338

117717

x14

ALS4-1032-225 Purchased No

270 Each

1,069.000 12 12



Insert



all 11/06/07

Location

Loc Qty

Loc Code

FP-B

28

110768

28

ST282

1041

110768

1041

x12

AN3C4A Purchased No

270 Each

1,984.000 6 6



BOLT



all 11/06/07

Location

Loc Qty

Loc Code

ST350

1984

117094

984

117313

1000

x6

Thursday, May 05, 2011 11:47:04 AM

Shop Packet Print

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Abstract

Required Date: 5/20/2011

Required Qty: 1.00

4




Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP-A	7	
115835	7	
ST350	1325	
115422	49	
<u>116419</u>	376	
116549	100	
117343	500	
117508	300	

10



washer

1117291  6101211 1106107

W/O: ,		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 69225
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: H	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	✓		Mori	Control
3.500	+/-0.010	3.503	✓		Mic with TG	ED-15
88.93	+/-0.030	88.934	✓		tape	EC-11
44.985	+/-0.030	N/A				
Ø3.200	+/-0.010	3.207	✓		micr	CNC-05
88.93	+/-0.030	N/A			05-11	
Ø3.750	+/-0.010	3.756	✓		micr	CNC-05
30° x 160" chamfer	+/-0.010	N/A				

Measured by: JFS / M.M.V. 11/05/31 **Date:** 11/05/31

Audited by: [Signature] **Date:** 11-05-31

HAAS Section						
1.526	+0.000/-0.030	1.511	✓		Vern	GA-01
7.500	+/-0.010	7.503	✓		Vern	CNC-02
27.750	+/-0.010	27.750	✓		TAPE	GA-12
31.750	+/-0.010	31.750	✓		"	"
35.250	+/-0.010	35.250	✓		"	"
3.300	+/-0.010	3.304	✓		Vern	GA-01
0.200	+/-0.010	0.204	✓		"	
3.520	+/-0.010	3.519	✓		Mic	GA-10
0.687	+0.010/-0.000	0.690	✓		Vern	GA-01
R0.062	+/-0.010	R0.063	✓		R-6	ref.
Ø0.484	+0.005/-0.001	Ø0.489	✓		Vern	GA-01

Measured by: JFS / M.M.V. **Date:** 11/05/11

Audited by: [Signature] **Date:** 11-05-31

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	

14071
302.8
1.2

12

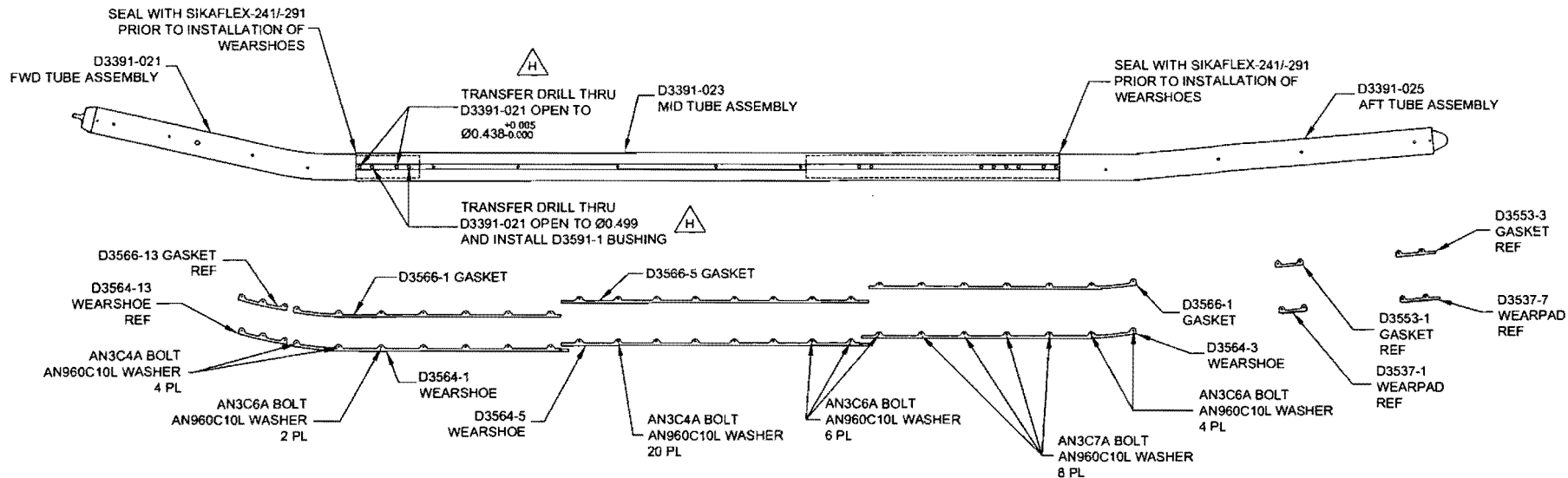
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

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MFG. APPR.		D3391	SHEET 2 OF 8
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u/019225

Dart Aerospace Ltd

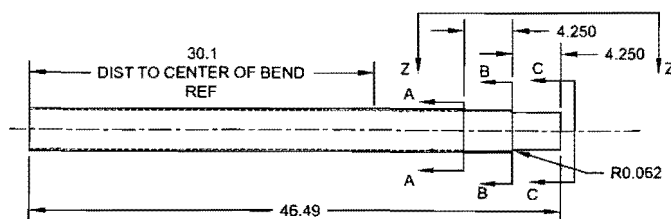
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

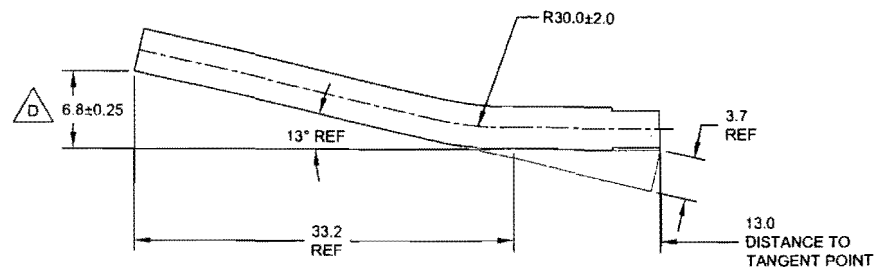
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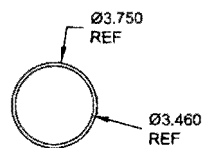
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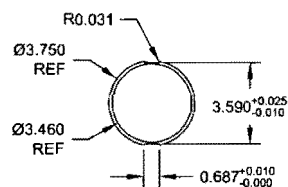
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



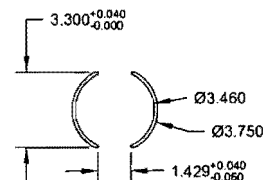
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



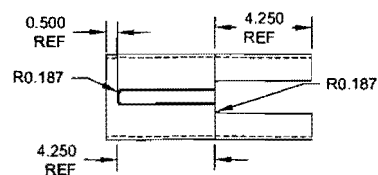
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

W6 69225

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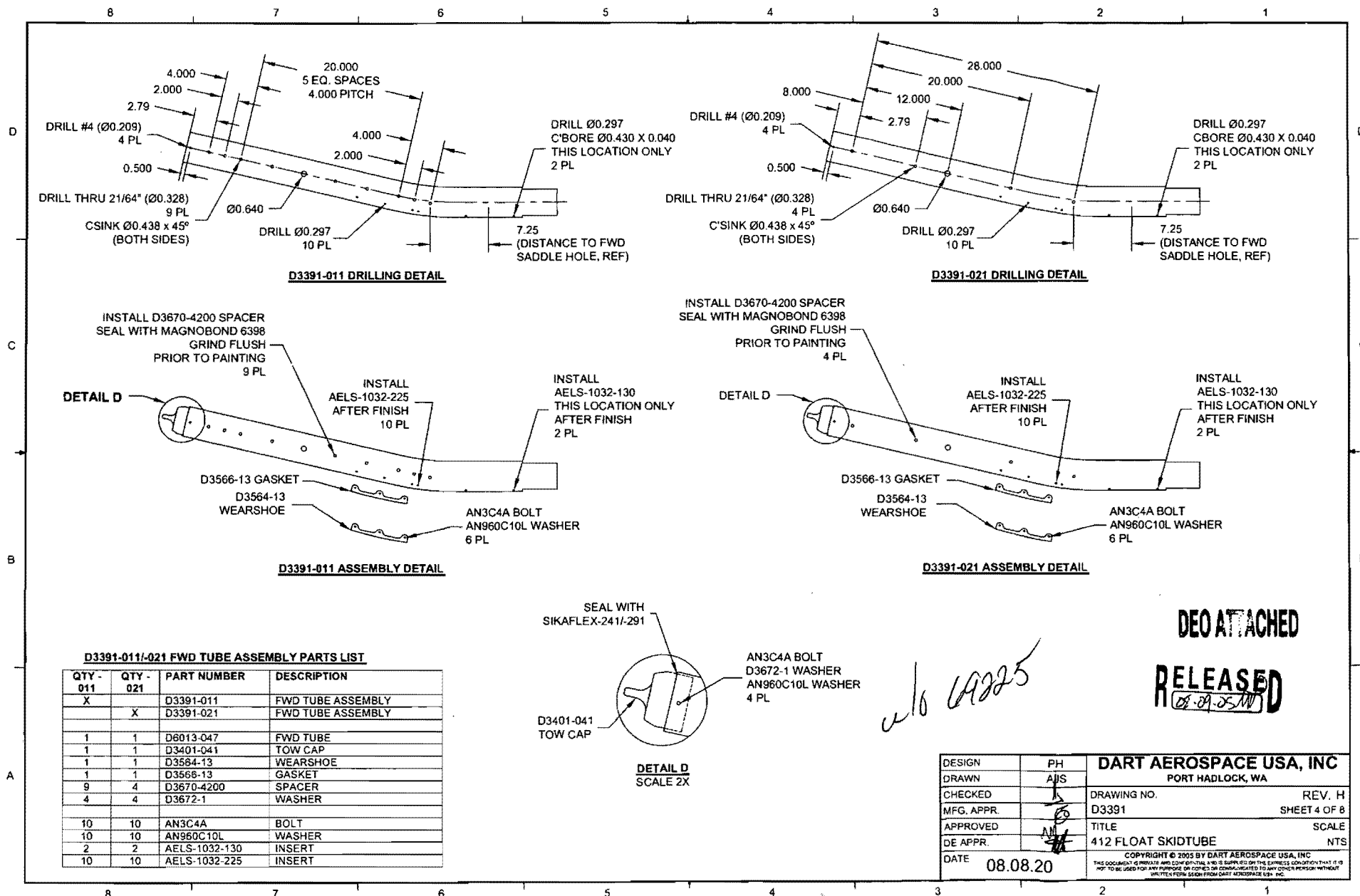
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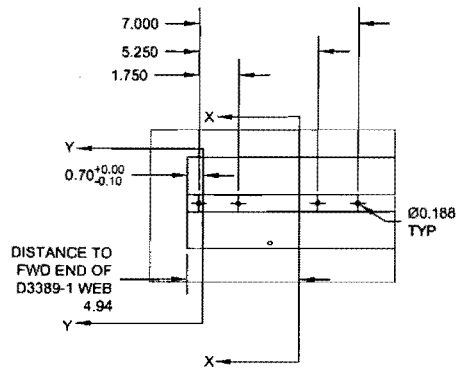
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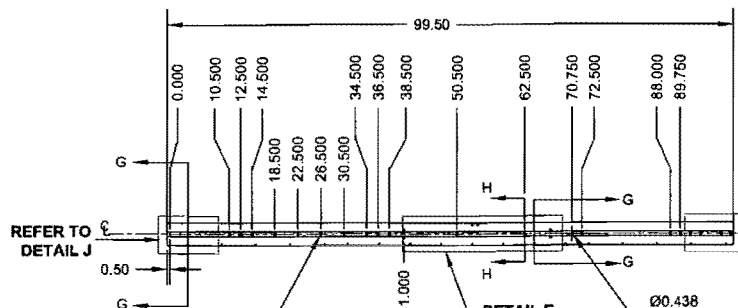
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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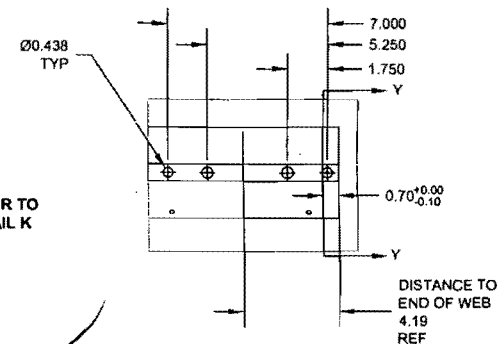


DETAIL J
SCALE 4X

DRILL THRU 21/64" (Ø0.328)
CSINK Ø0.438 X 45° (BOTH SIDES)
12 PL



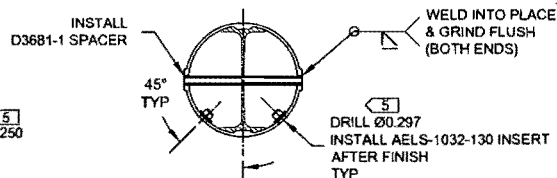
D3391-013 ASSEMBLY DETAIL



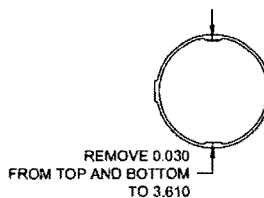
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SCALE 4X



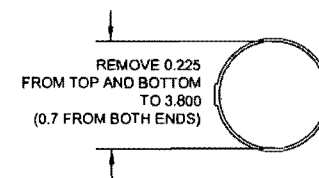
SECTION G-G
SCALE 5X



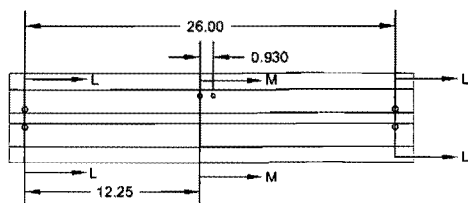
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SCALE 5X



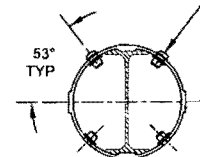
SECTION X-X
SCALE 5X



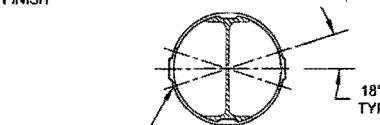
SECTION Y-Y
SCALE 5X



DETAIL E
SCALE NONE



SECTION M-M
SCALE 5X



SECTION L-L
SCALE 5X

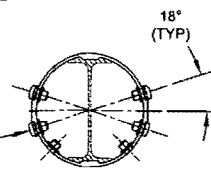
D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

DRILL Ø0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
AN960C416L WASHER
AFTER FINISH
4 PL



SECTION L-L
SCALE 5X

DEO ATTACHED

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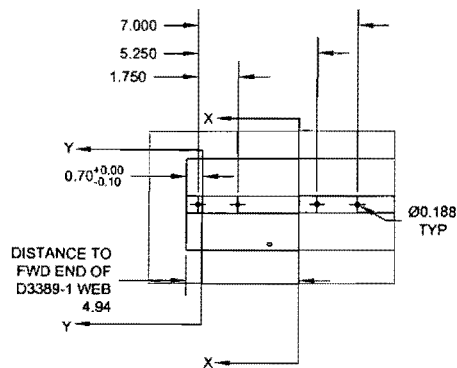
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

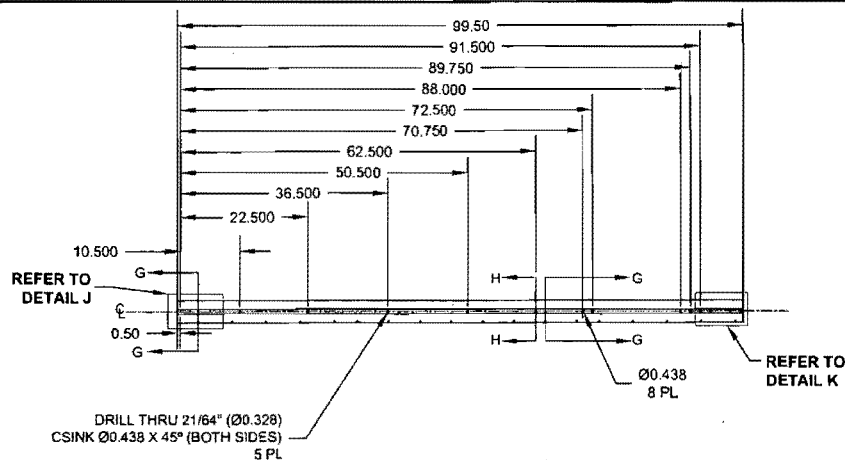
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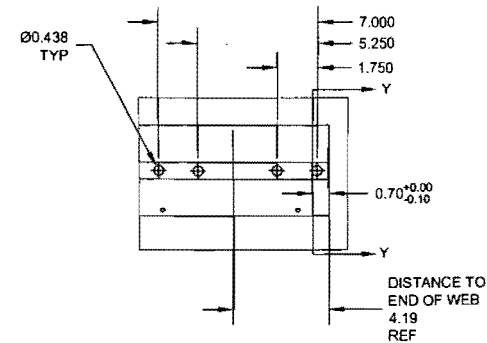
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DETAIL J
SCALE 4X



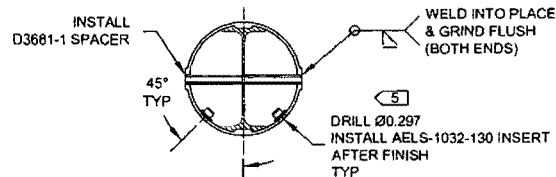
D3391-023 ASSEMBLY DETAIL



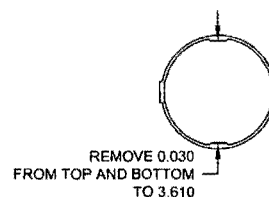
DETAIL K
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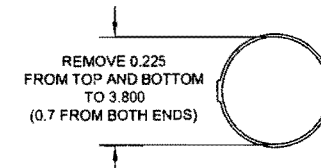
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

DEO ATTACHED
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(8-25-14)

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u/0 69225

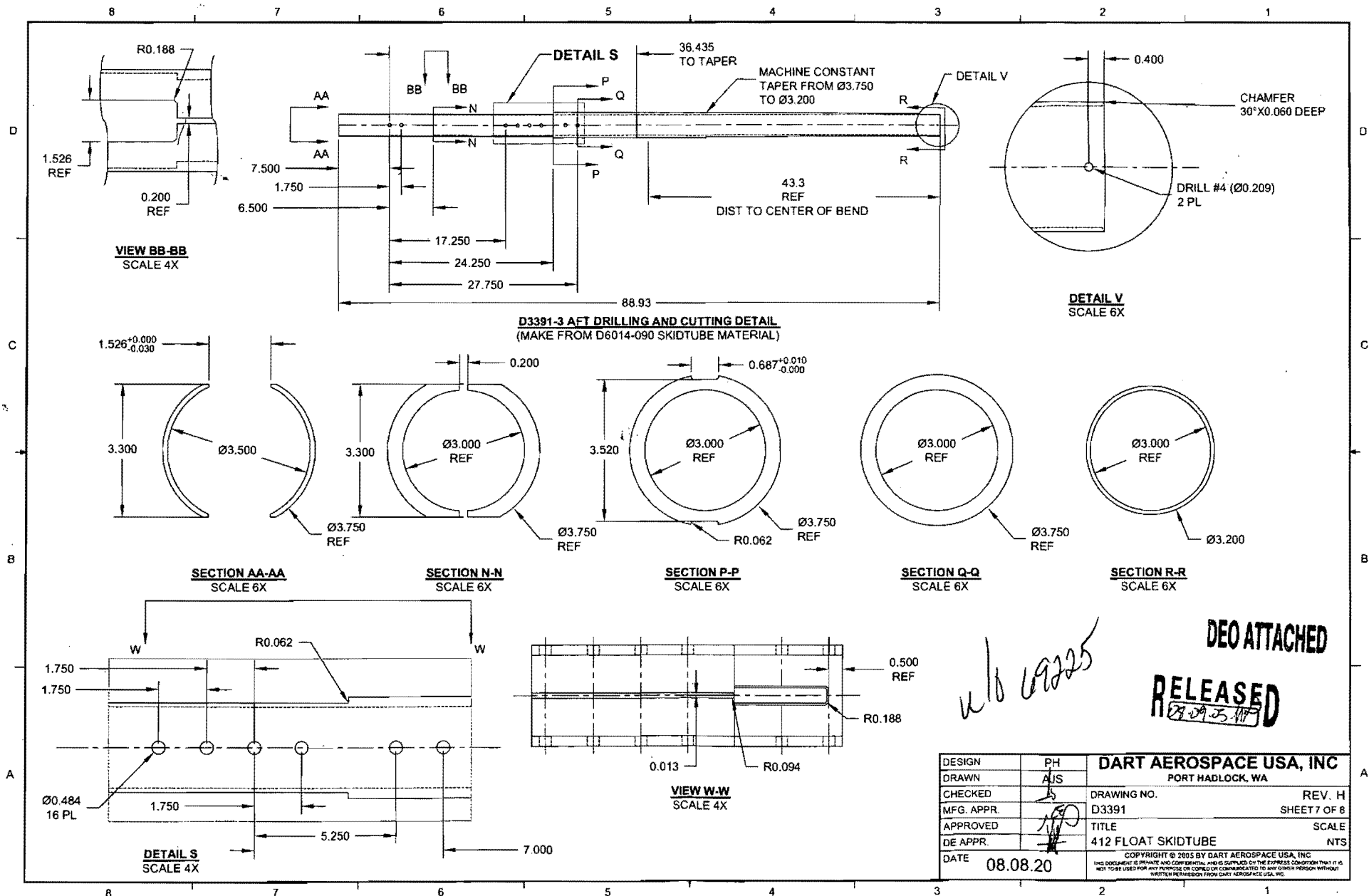
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NOTE: Date & initial all entries



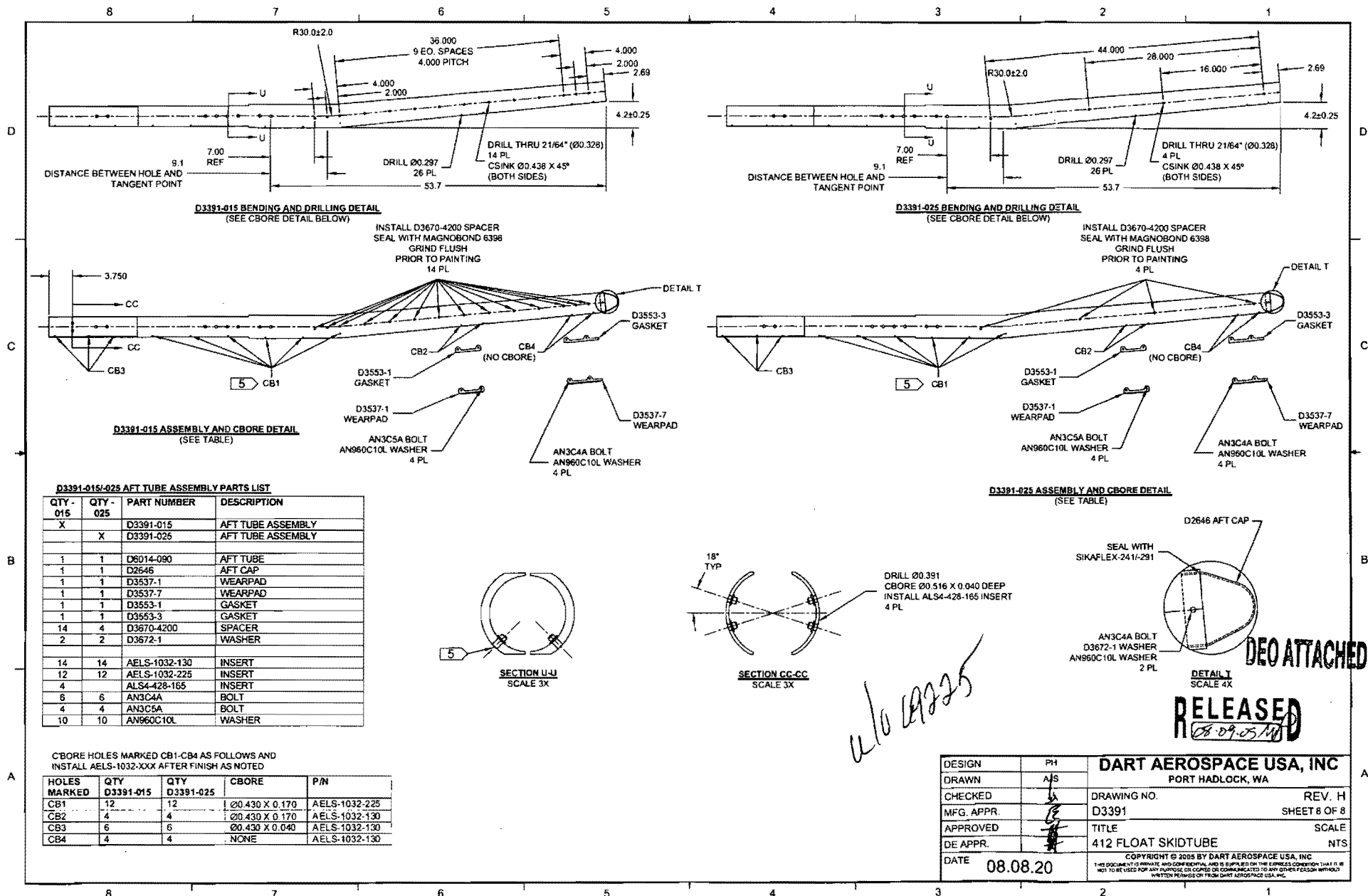
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>MP</i>	CHECKED <i>1</i>	MFG. APPR. <i>MS</i>	APPROVED <i>MP</i>		DE APPR. <i>MP</i>		
DATE 09.09.23	DATE 09.09.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02

MP

u/o 69825

W/O:		WORK ORDER CHANGES					
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